





MAIN PRODUCT-PROPERTIES

- High-grade, mat High-Solid alkyd resin Monolayer for corrosion protection of steelparts for a plenty of applications, e.g. steel hall-, machine- and apparatus construction
- Monolayer for corrosivity categorie up to C2, especially interior
- Together with suitable top coats as priming coat also for higher stresses
- Processing occurs preferred in the shop by airless-spraying with film thicknesses of 80 to 120 µm

PRODUCT DATA

GEHOLIT-K65	RAL-colours, mat
	K65-M.... .RAL-colours (other colours on request)
	Mixing ratio by weight not relevant
	Thinner V-89

GEHOLIT-K65	Guideline RAL-colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (mL/kg)	
	1.55	78.0	22.0	61.0	395
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	131	4.5	0.205	4.9

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m² at DFT 10 µm

3) Theoretical consumption related on a smooth surface. Dependent on surface roughness and processing losses different consumption data will be achieved in practice

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airless /
Airmix



High
pressure



Roller/Brush
application ⁴⁾

Application viscosity (s) (4 mm DIN-cup)	13 to 15	6 to 10	13 to 15
Nozzle diameter (mm)	0.33 to 0.68	1.5 to 2.0	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 120	80 to 120	60 to 80
Addition of thinner (%)	0 to 3	4 to 6	0 to 2

* DFT = Dry Film Thickness

4) recommended only for smaller areas

COMMENTS ON PROCESSING



Pot life
not relevant

Drying/Curing times at 80 µm DFT

Ambient air temperature 20 °C



dust-free:

after 30 minutes



Tack-free:

after approx. 2 hours



overcoating interval / dry to handle:

after approx. 4 hours

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
i ("One-pack performance coatings") Type SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 1/2 according to EN ISO 12944-4

Existing primer coats - or prefabrication primer

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of other priming coats compatibility tests are recommended



Air and surface temperature
≥ 5 °C




relative humidity ≤ 80 %
dew point distance ≥ 3 °C

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coats / Monolayer	GEHOLIT-K65	80 to 120
	Optional Top coats	GEHOLIT-K48 GEHOLIT-K64 GEHOTEX-W92	40 to 60 80 to 120 60 to 80

SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at www.geholit-wierner.de.

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied. This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.